

Work Order ID 164486

Wednesday, July 19, 2017 2:41:35 AM

164486

Page 1

Item ID: D3560-4 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Arm
Start Date: 7/27/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3560	Rev D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.06

Jeaspa Bandsaw

Cut blanks 15.500" long

2 _____ S.C. 17/07/28

110

0.85

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.81

HAAS CNC vertical machine #1

1- Mill as per Folio FA696 Rev: A & Dwg D3560 Rev: D

2-Deburr per dwg D3560

2 $\emptyset$ _____ DAS 49 9-89 17/07/31

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.02

Quality Control

2 $\emptyset$ _____ DAS 49 9-89 17/07/31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
122 *122* Mill Conv Conventional Milling Machine	Manufacture as per dwg Memo -C'sink 0.196" hole on manual mill as per dwg D3560	0.00 0.12				2	Ø		DAS 32 9-89 17-08-09
124 *124* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				2	Ø		DAS 32 9-89 17-08-09
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.04				2	Ø		DAS 44 9-89 17-08-14

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Page 3

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 7/27/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/4/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: WA003	0.00							
210									
Packaging	Memo	0.02		DAS 6 9-89		2		AUG 21 2017	ml
Packaging	LOCATION: WA003								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.20						DAS 21 9-89	AUG 24 2017
Quality Control									

DAS
21
9-89**UN 17/8/21**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Wednesday, July 19, 2017 2:41:37 AM

Page 1

Work Order ID: 164486

164486

Parent Item: D3560-4

D3560-4

Parent Item Name: Arm

Start Date: 7/27/2017

Required Date: 8/4/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-11-10 JLM use-044
13.06.03 PER DWG REV.F DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.00 0		Purchased	No			100	f	24.0450	1.39	2.926316			

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

Location

Loc Qty

Loc Code

MAT001

24.045

m130527

0.045

m134984

12

m136882

12

S.L.
17/07/18
2.9 2.9

DQA: _____ Date: _____

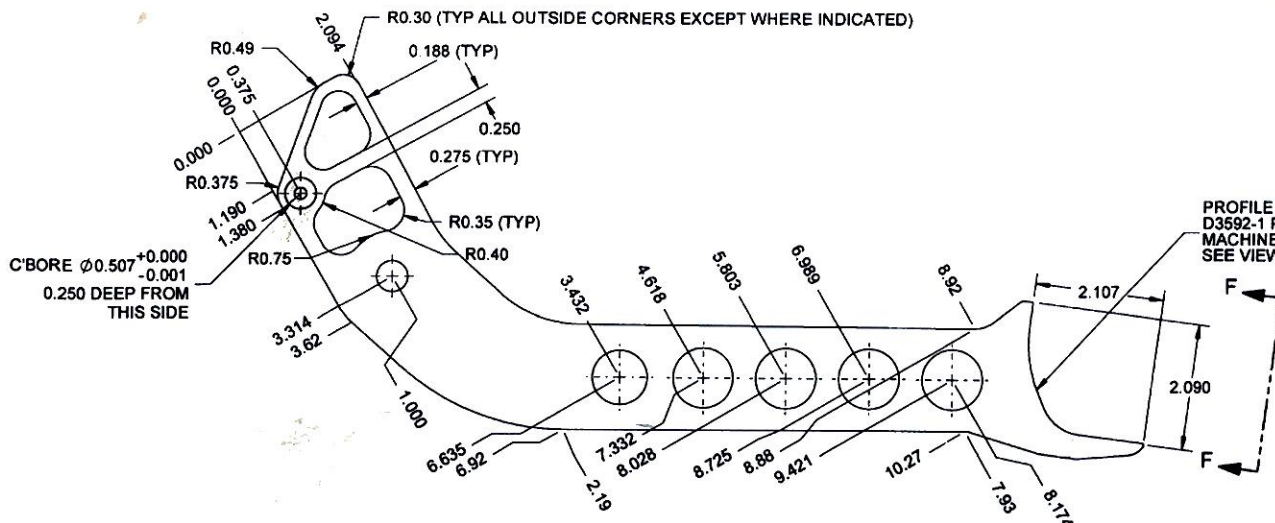


WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

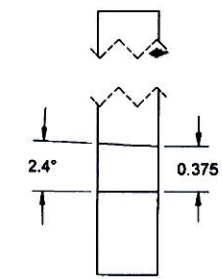
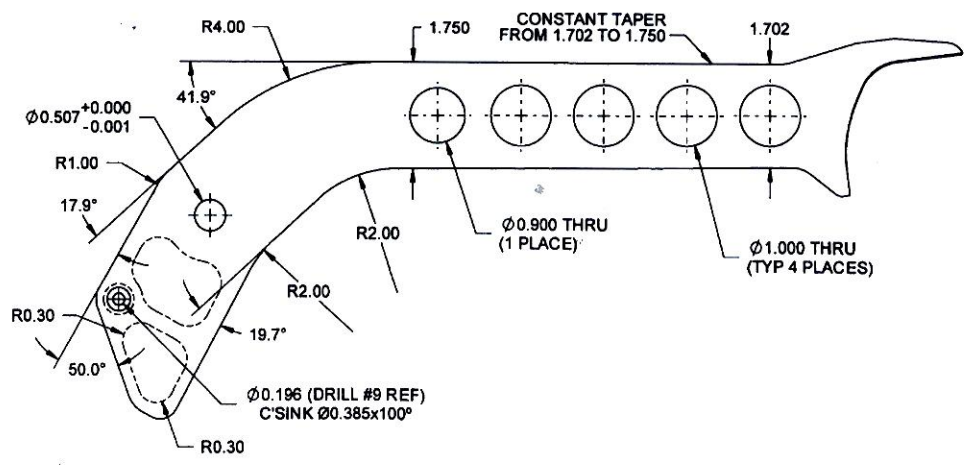
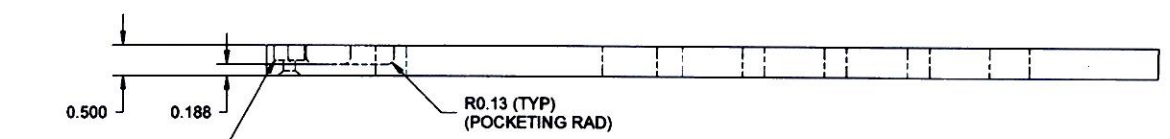
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *164486 MJS*
170720

D3560-4 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

RELEASED
16-12-14 MJS

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	BC	D3560	SHEET 5 OF 5
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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